

MUST SHIP FRIDAY OCT 30

Work Order ID 53262-2



Page 1

October 29, 2009 11:05:34 AM

Item ID: D3709-3

Revision ID: A

Item Name: Angle

Start Date: 10/29/09 Start Qty: 1.00

Required Date: 10/30/09 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 □ Dwg Rev: A □ Prog Rev: A

□

****grain direction on a 45 degree **** □ 2- Debur if necessary

109-29

3

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

109-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2/802/10/09

3

6

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Page 2

Item ID: D3709-3

Accept



Setup Start



Revision ID: A

Item Name: Angle

Stop



Start Date: 10/29/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

0.00

50 09/11/18

1

0

Small Fab

Memo

Form as per dwg D3709

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

27 09/11/18

0

0

Memo

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

11 09/11/19

1

0

Memo

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Page 3

Item ID: D3709-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 10/29/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



0.00

QC

Memo

0.00

Quality Control

PL 09-11-19

①

170

Identify as per dwg & Stock Location: _____

0.00



0.00

Packaging

Memo

Packaging

1914/23①

180

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

① 09/11/24

MF 09-11-23

Picklist Print

October 29, 2009 11:05:33 AM

Page 1

Work Order ID: 53262

Parent Item: D3709-3RevA

Parent Item Name: Angle

Comments:

Start Date: 10/29/09

Required Date: 10/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

227.7841

0.2800



LB 9-10-09

6061-T6 .063 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

227.7841211

110551

33.2841211

112939

194.5

112939

w/o 53262

D3709-3 ANGLE

D3709-1 ANGLE

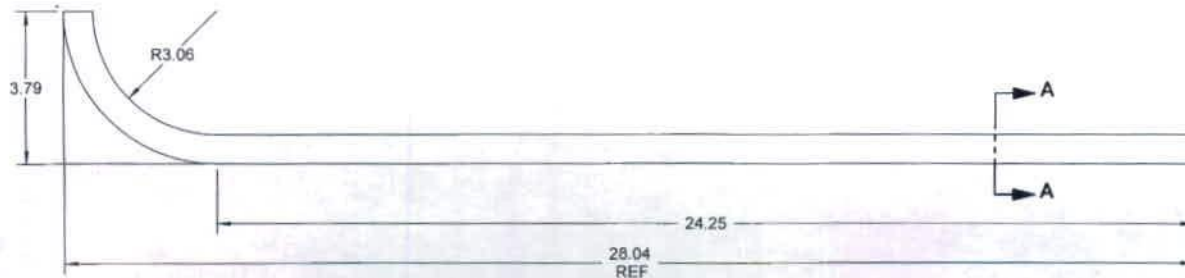
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2/6/1979

NOTES:

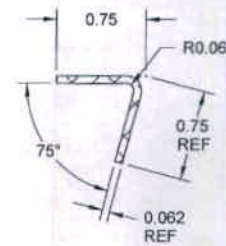
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

A	NEW ISSUE	MB	08.05.02
REV.		DESCRIPTION	SY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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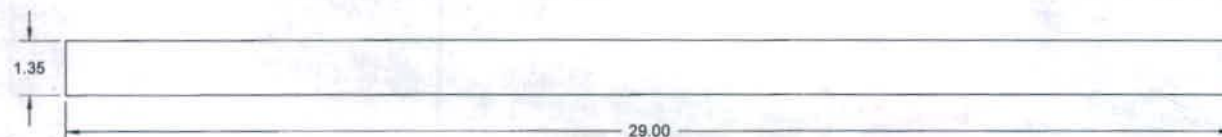
u/o 53262



D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X

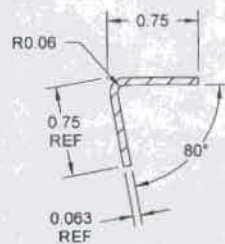


D3709-1F ANGLE FLAT PATTERN

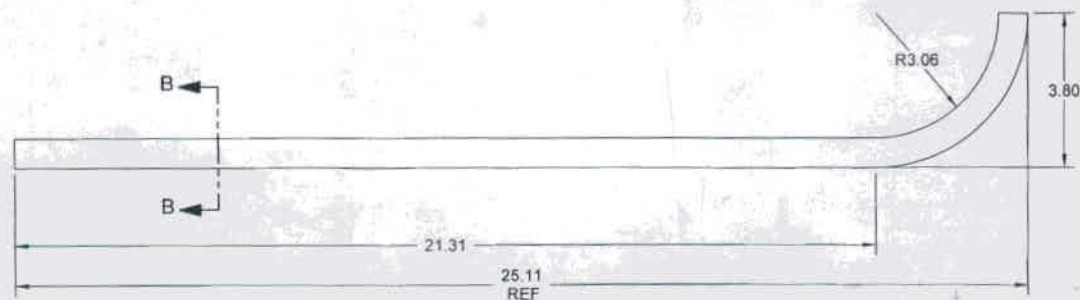
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w/053262

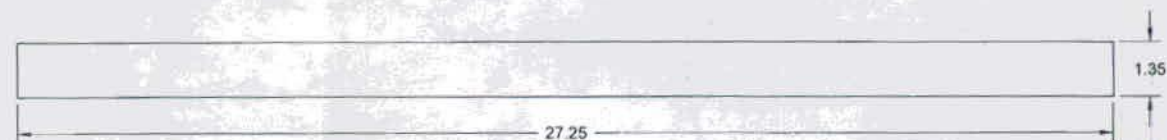


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

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07/04/03/14

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